

Date: Monday, 14/07/2008 8:26:45 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 EXTRUSION BENDING
Job Number :	40451		
Estimate Number :	10311		
P.O. Number :		Part Number :	D2620
This Issue :	14/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2620 REV B
First Issue :	1/1	Project Number :	N/A
Previous Run :	39178	Drawing Revision :	B
	Type :	Material :	
	SKIDTUBES	Due Date :	21/07/2008
Written By :		Qty:	20
Checked & Approved By :		Um:	Each
Comment :	Est. D 02/07/26 Change Dwg to rev.B; Updated Location RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26001160	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	24508/34715

Batch

24508/34715

712

ET 08-07-14

x20

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A
 and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 08/07/14

x20

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: SKID tube cell

ET 08-07-14

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

08/07/15

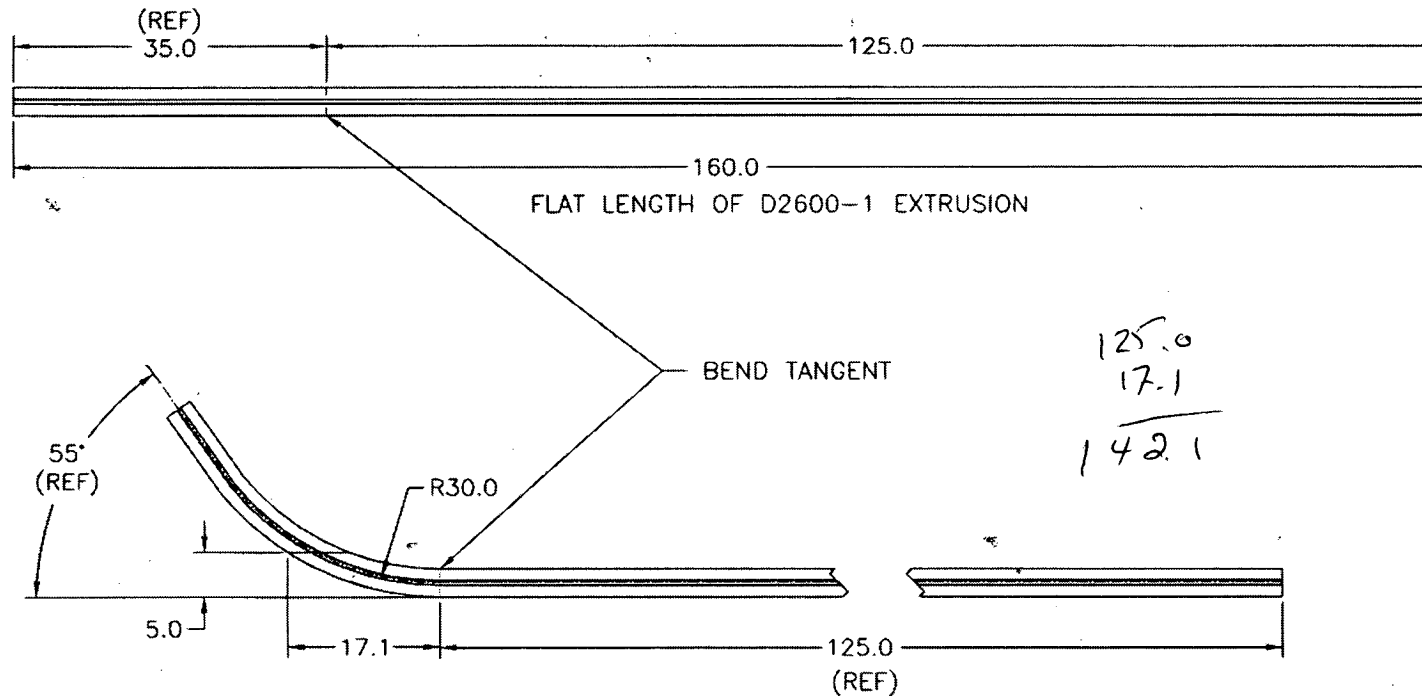
Job Completion



MF 08-07-14

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE 1:20

RELEASED
99 09 15 DS

W/O 1451

